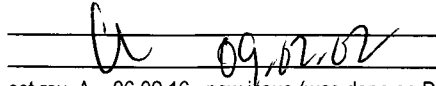
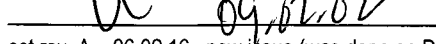


Date: Wednesday, 18/02/2009 2:54:38 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SIDE DOOR
Job Number :	45404		
Estimate Number :	12295		
P.O. Number :		Part Number :	D350589041
This Issue :	18/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2991 REV.C
First Issue :	02/02/2009	Project Number :	N/A
Previous Run :	45403	Drawing Revision :	C
	Type :	Material :	
	PURCHASED PARTS	Due Date :	20/02/2009
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN 1096 DD verified by:EC est rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041

CHG003

for JUD 09/03/1168 09/03/09
 6 HG 004 PRO 09/05/2011 HA for JUD

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8112

C209/02/03 0

Description: D2991-1 side door

Supplier: Delastek

batch:

Ship to delastek: Qty 2 D2992-1 Doublers

B28743

B47667

C209/02/03 (2)

C209/03/25 (2)

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

B46789 C209/04/15 (2)

3.0	D29921	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

C209/02/03

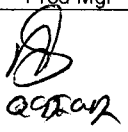
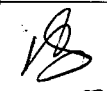
4.0	D29911	Side Door
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Side Door

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.04.27	1	DZ992-1 NOW WIDER KIT @ CHG 004				 09.04.27	 09.05.28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:54:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45404

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

**ENGINEERING
APPROVAL**

09/105/28 ① 09.05.28

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

09.05.28 ①

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description
1	D2464-1700	Foam seal

Batch

839669

090529

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2585	Latch clamp

Batch

45815

4 DS19463

PTO →

09/105/29 ①

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2586	Door latch

Batch

45554

4 DS19463

09/105/29 ①

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2621	latch plate

Batch

41175

4 DS19463

09/105/29 ①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090529	8.	quantity changed to accommodate DSI 9463 9463 (Latch and Hardware)	<i>[Signature]</i>	090529	1	<i>[Signature]</i> 090529 P 051042	<i>[Signature]</i> 090529	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:54:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45404

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description
1 D3085-041 prop ass'y

Batch

B45557

8809105/29 (X)

12.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~6.0000~~ Each(s)

Pick:

Qty Part number Description
6 MS21042L3 Nut

Batch

M10844

700 DSI 9463

8809105/29 (X)

13.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: ~~3.0000~~ Each(s)

Pick:

Qty Part number Description
3 AN960JD10 Washer

Batch

M111279

4 DSI 9463

PTO
8809105/29 (X)

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: ~~3.0000~~ Each(s)

Pick:

Qty Part number Description
3 MS27039-1-15 Screw

Batch

M110915

4 DSI 9463

8809105/29 (X)

15.0

D37211

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Decal

batch:

45492

8809105/29 (X)

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

090528 PTO →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090529	16	core removed and two layers of 9oz cloth to accomodate Latch placement of DSI 9463 9oz cloth FG78150350 M111166 9330 Hysol M110970	W	09-05-28	1	W 05.04.29 pc DSI 412	W 09-05-29	
090529	13	Change washers to 10L M109632 Permanent Change	W	090529	1	W 090529	W 09-05-29	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:54:39 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45404

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.05.29 @

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Switch Plate

Batch:

46896

09.05.29 @

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Doubler

Batch:

45585

09.05.29 @

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

4

D2237

Striker Plate

46162

4 DS1 9463

09.05.29 @

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1

D2589

keys, key chain

46840

09.05.29 @

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

AN3-4A

Bolt

M163915

09.05.29 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:54:39 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45404

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~6.0000~~ Each(s) 8 ~~10~~ DSI 9463

Pick:

Qty Part number Description Batch

MS20470AD4-5 Rivet

M 09031

8809105/29 (RF)

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

M 110844

8809105/29 (XC)

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8809105/29 (X)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: E

9/5/29

(K)

S

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8809105/29 (1)

Job Completion



POSITIVE RECALL

EFFECTIVE 09.04.27 AUTH UP

RELEASED UP DATE 09.05.29

MF 09-05-29

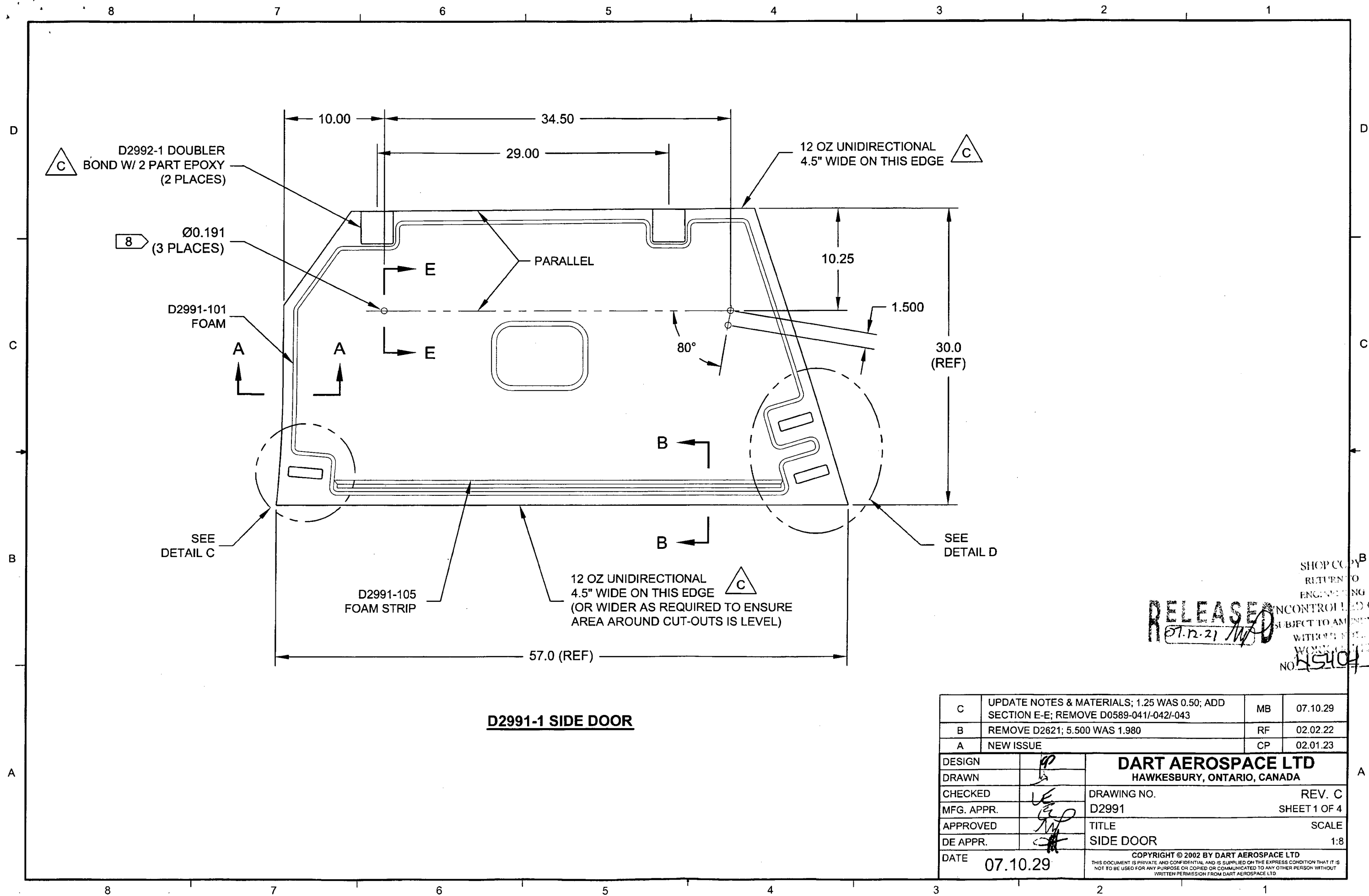
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

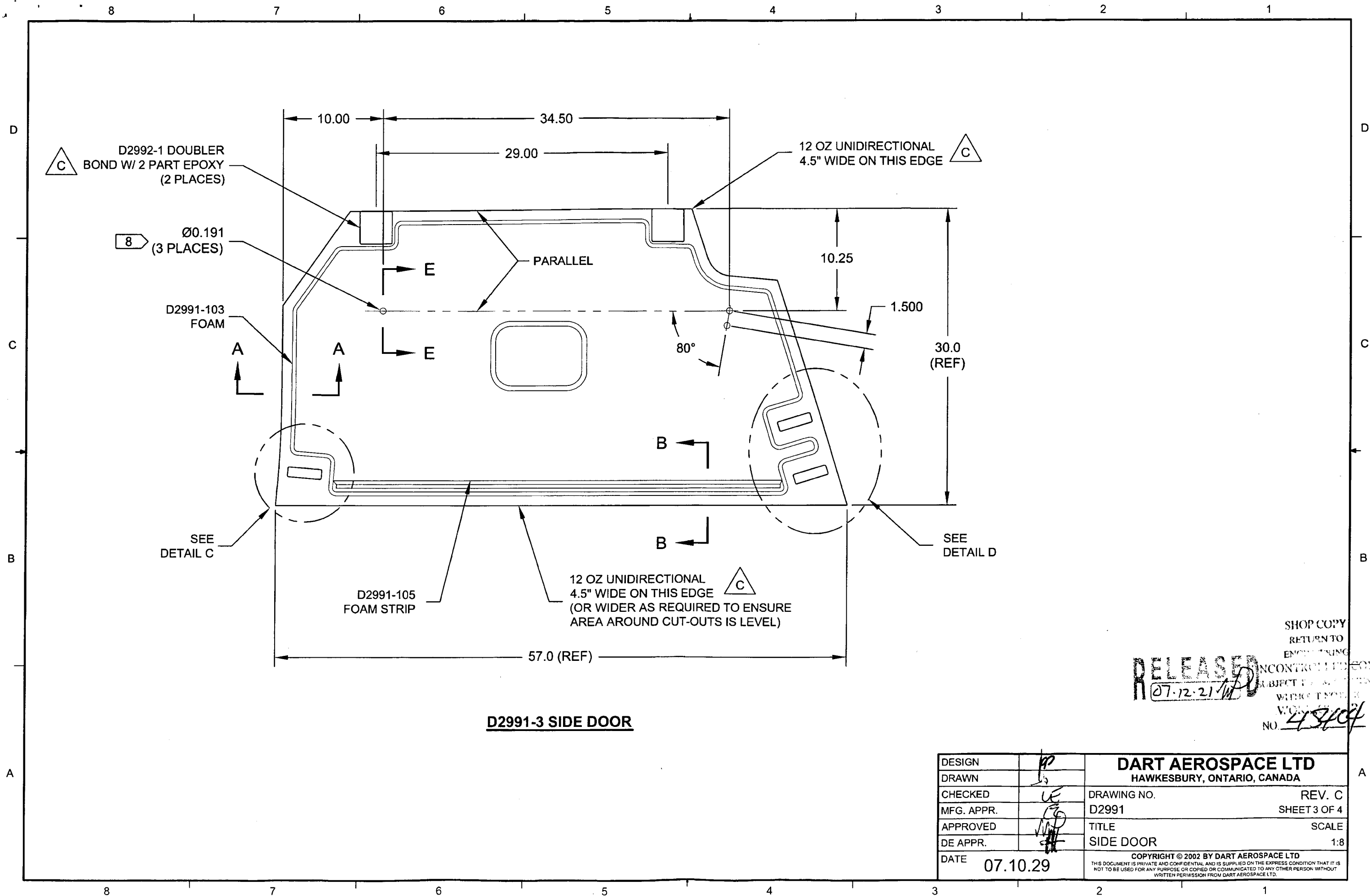
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



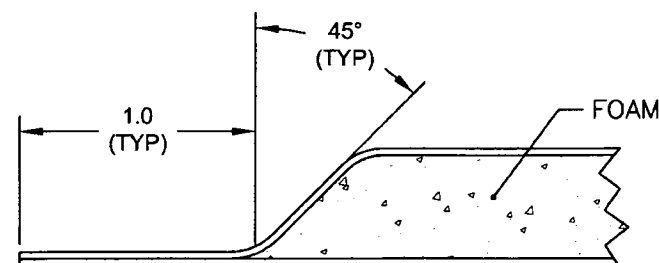
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LE		
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	LE	D2991	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO
WORK ORDER
NO. 48404

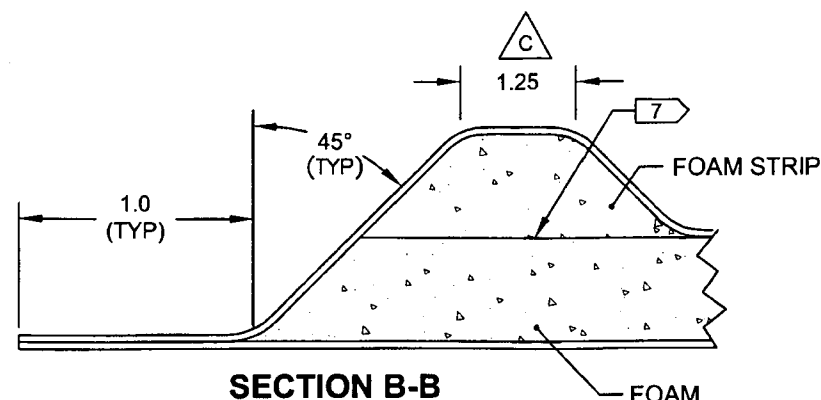
RELEASED 07.12.21

DESIGN	lp	DART AEROSPACE LTD	
DRAWN	ls	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	LE	D2991	SHEET 3 OF 4
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DE APPR.	WJ	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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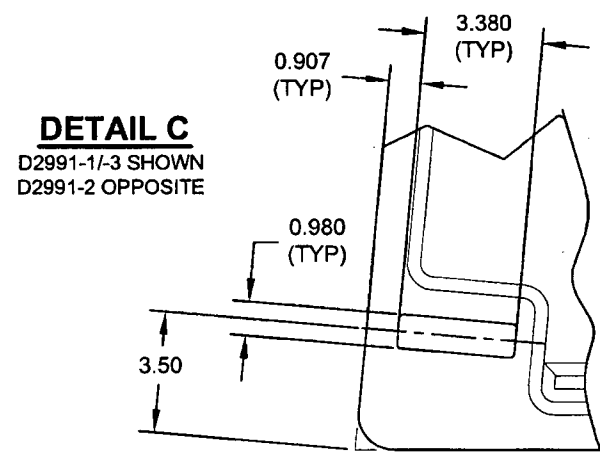
SECTION A-A

NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



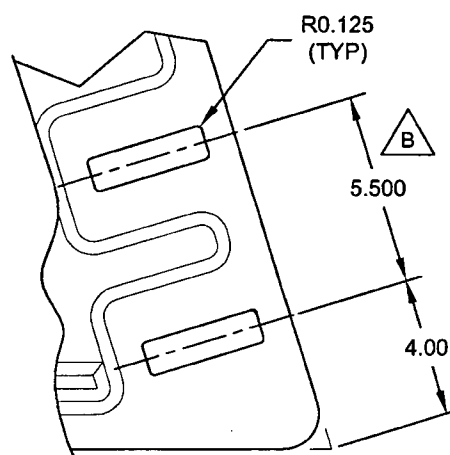
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



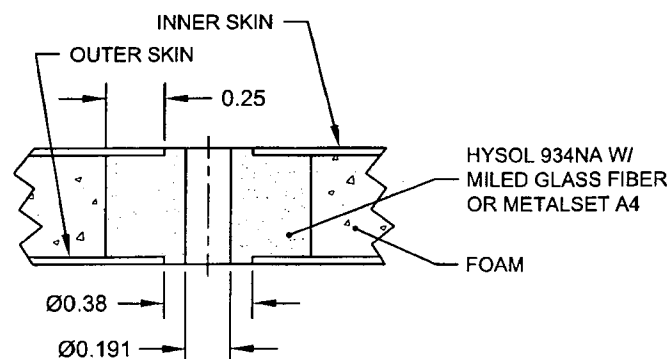
DETAIL C

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/-2/-3

- LAYUP PER QSI 006 AND AS FOLLOWS
- MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- BOND FOAM CORE USING POLYBOND B46F
- DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- WEIGHT: 9 lbs (TYP)

RELEASED
07.12.21

DESIGN	42	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	5	DRAWING NO.	REV. C
MFG. APPR.	5	D2991	SHEET 4 OF 4
APPROVED	5	TITLE	SCALE
DE APPR.	5	SIDE DOOR	1:1
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13170
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/05/2009	03/02/2009	5973	Chantal Lavoie		PO00008112		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B45404 Dwg.: D2991 Rév.: C annoté Job: 43779 U de M : Each			
1	0	1	DKC134-0051	Side Door N° D2991-2 B45407 Dwg.: D2991 Rév.: C annoté Job: 43779 43781 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:



Quality department

AQ-357



le: Jeudi, 2009-04-23 08:40:43
 l'isaleur: Marc Dubé

Feuille de Procédé

lient	: DART	Dart Aerospace Ltd.	Nom Dessin	: SIDE DOOR N° D2991-1	6	
uméro Job	: 43779		Numéro Article	: DKC134-0066	134-0050	
uméro Soumission	: 2642		Numéro Dessin	: D2991		
uméro B.A.	:		Projet Numéro	: DKC134		
ette fois	: 2009-04-23	No. B.V. :	Révision dessin	E Revision canoté		
rsht Rev.	: NC		Matériel	: Composites		
rem. fois	: - -	Type :	Date Dûe	: 2009-04-30	Qté:	1 Udm: UNITE
ob précédente	: 43778					
crit par	:					
érifié & Approuvé par	:					
ommentaires	:	N° de pièce Client: D2991-1.				

Process Sheet Rev.: 00 Création du premier.


roduit additionnel

uméro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0582 Frekote 700NC N° 38425

Commentair Qty.: 0.025 GALLON(s)/Unit Total : 0.025 GALLON(s) #Lot: 

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART




Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs


Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: 23-4-09 Sceau:  


3.0 AAC0273 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s) #Lot: 1-7047-1 

4.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0250 UNITE(s)/Unit Total : 0.0250 UNITE(s) #Lot: 1-22176-1 

5.0 AAC0198 UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s) #Lot: 

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

 Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à
 l'aide de 5% de UN2055 styrene monomere ST

 11-05-09
 Date: 24-4-09 Sceau:  Temps Début: 8:10 Temps Fin: 8:25

Date: Jeudi, 2009-04-23 08:40:43

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43779

Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 GEL COAT. APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du gel coat sur le moule N° DKO-0094 selon IG 0019

11-5-09
Date: 24-4-09

Sceau:



8.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0 AC0407 Wrighton 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0 AAC0276 Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s) # Lot: 1-2019-1



13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s) # Lot: 1-21729-1



14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

11-5-09
Date: 15-4-09

Sceau:



Date: Jeudi, 2009-04-23 08:40:43

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43779

Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

16.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s) # Lot: 1-24094-1

17.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0060 UNITE(s)/Unit Total: 0.0060 UNITE(s) # Lot: 1-22176-1

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 11-5-09 24-4-09 Heure Début: 12:30 Heure Fin: 12:35 Sceau: DELASTEX COMPOSITE 34

19.0 LAMINAGE LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0094 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 11-5-09 24-4-09 Heure Début: 12:35 Heure Fin: 1:00 Sceau: DELASTEX COMPOSITE 34 DELASTEX COMPOSITE 7

20.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Date: 11-5-09 24-4-09 Sceau: DELASTEX COMPOSITE 34 DELASTEX COMPOSITE 7

Curing début: 12:35 Curing Fin: 8:00

















21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total: 0.143 KIT(s) # Lot: 1-6986-1

22.0 DKC134-0062 Foam Core N° D2991-101 (Porte D2991-1)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) # Job: 43800

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SIDE DOOR N° D2991-1	
Numéro Job: 43779		Numéro Article: DKC134-0066	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
23.0	ASSEMBLAGE 3 	ASSEMBLAGE GÉNÉRALE DART 	
<p>Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs</p> <p>Retirez le bagging.</p> <p>Installer le Foam Core selon IG 0033</p> <p>Date: <u>21-5-09</u> <u>27-4-09</u> Heure Début: <u>10:30</u> <u>8:05</u> Heure Fin: <u>10:45</u> <u>8:20</u> Sceau:  </p>			
24.0	POCHE À VIDE 1 	FAIRE LA POCHE À VIDE 	
<p>Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs</p> <p>Faire la poche à vide selon IG0012</p> <p>Laisser sécher pendant 2 heures minimum.</p> <p>Date: <u>21-5-09</u> <u>27-4-09</u> Sceau:  </p> <p>Curing Début: <u>10:30</u> <u>10:30</u> Curing Fin: <u>11:35</u> <u>9:20</u></p>			
25.0	AAC0274	Derekane 411-350 Promoté N° RV411B3020	
<p>Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s) # Lot : <u>1-24094-1</u> </p>			
26.0	AAC0275	Catalyst N° DDM-9	
<p>Commentair Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s) # Lot : <u>1-22176-1</u> </p>			
27.0	PRÉPARATION 3 	PRÉPARATION DU MATÉRIEL DART 	
<p>Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs</p> <p>Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.</p> <p>Date: <u>21-5-09</u> <u>10:45</u> <u>1:50</u> Heure Début: <u>10:15</u> <u>10:20</u> Heure Fin: <u>10:20</u> Sceau: </p>			
28.0	LAMINAGE 	LAMINAGE PIÈCE DART 	
<p>Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs</p> <p>Faire le laminage d'un pli de 9.7 oz.</p> <p>Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent</p>			

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43779

Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

Faire le laminage du dernier pli de 9.7 oz.

Date: 21-5-09 Heure Début: 1:50 Heure Fin: 2:20 Sceau: 34



29.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 21-5-09 Heure Début: 2:20 Heure Fin: 2:30 Sceau: 34



Curing Début: 1:50 Curing Fin: 8:00

30.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 22-5-09 Sceau: 34



31.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit N° DK0-0118 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 22-5-09 Sceau: 34



32.0

AAC0433

Hysol 934NA part A&B (quart kit)

Commentair Qty.: 0.150 KIT(s)/Unit Total: 0.150 KIT(s)

Lot: 1-28083-1



33.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0002 GALLON(s)/Unit Total: 0.0002 GALLON(s)

Lot: 1-6872-1



Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 43779

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

34.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0118 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 22-5-09 Sceau:



35.0 TRIMAGE TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKO-0118 Repercer les 3 trous de 1/4" Dia.

Date: Sceau:

Avaldite 2043 22/05/09 m.g.

36.0 AAC0433

Hysol 934NA part A&B (quart kit)

Commentair Qty.: 0.125 KIT(s)/Unit Total: 0.125 KIT(s)

Lot: 1-24284-1



37.0 AAC0697

N° D2992-1, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

Lot: 1-7063-1



38.0 ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÉCES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

ARALDITE

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 25 mai 09 Sceau:




Feuille de Procédé

Client: DART Dart Aerospace Ltd.	Nom Dessin: SIDE DOOR N° D2991-1
Numéro Job: 43779	Numéro Article: DKC134-0066


Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

39.0	AAC0683	Dupont Primer N° 7704S
Commentair Qty.: 0.1800 UNITE(s)/Unit		Total : 0.1800 UNITE(s)

#LOT: L-22968-1 

40.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S
Commentair Qty.: 0.0450 UNITE(s)/Unit		Total : 0.0450 UNITE(s)


#LOT: L-23133-2 

41.0	PRIMER	APPLICATION DE PRIMER
------	--------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

Date: 26/05/09 Sceau: 

1x 27/05/09 (Primer final)

42.0	INSPECTION 3	INSPECTION PIÈCE DART
------	--------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: 27-05-09

Heure Début: _____ Heure Fin: _____ Sceau: _____

No Trim jig


 

43.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
------	-----------	--------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: 1 Date: 27-5-09 Sceau: 

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E

AND

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1

REF CANADIAN STC: SH92-41

REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw


The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.







Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

45404

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED


BY: 
D. SHEPHERD (DE # 02)
DATE: 09.05.26
CERT. NO.: SH92-41
ISSUE NO.: 8






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To install the DSI-9463-011 Door Latch Kit:

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.

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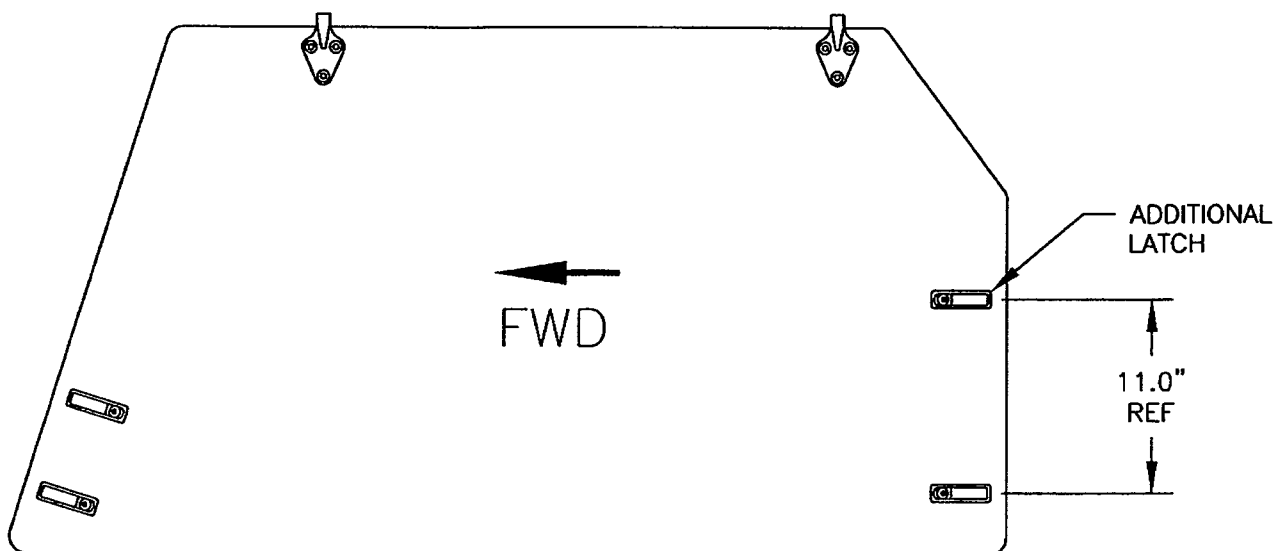


FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)
D35X-589-042/-043 (SIMILAR)







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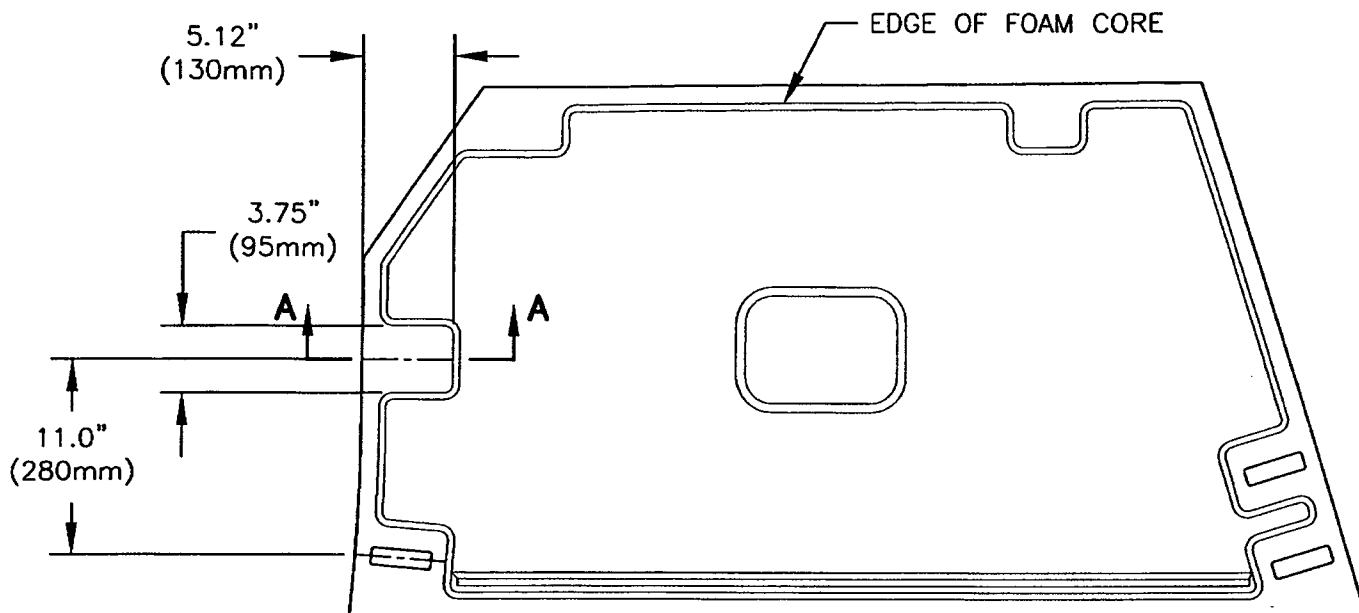
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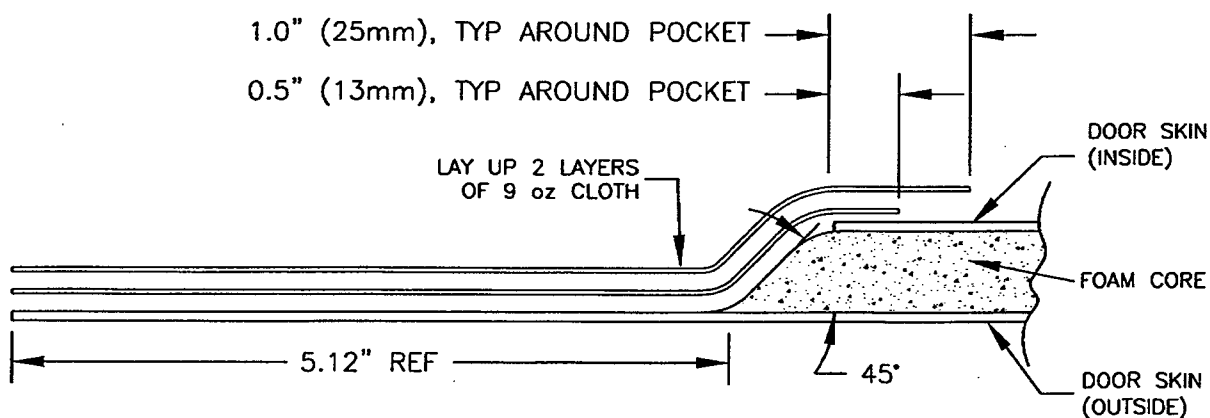
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**FIGURE 2: TRIMMING FOAM CORE
(VIEW LOOKING AT INSIDE OF DOOR)
(-041 SHOWN, -042/-043 SIMILAR)**



SECTION A-A

45404

CANADA
DEPARTMENT OF TRANSPORT
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SEE
DETAIL B

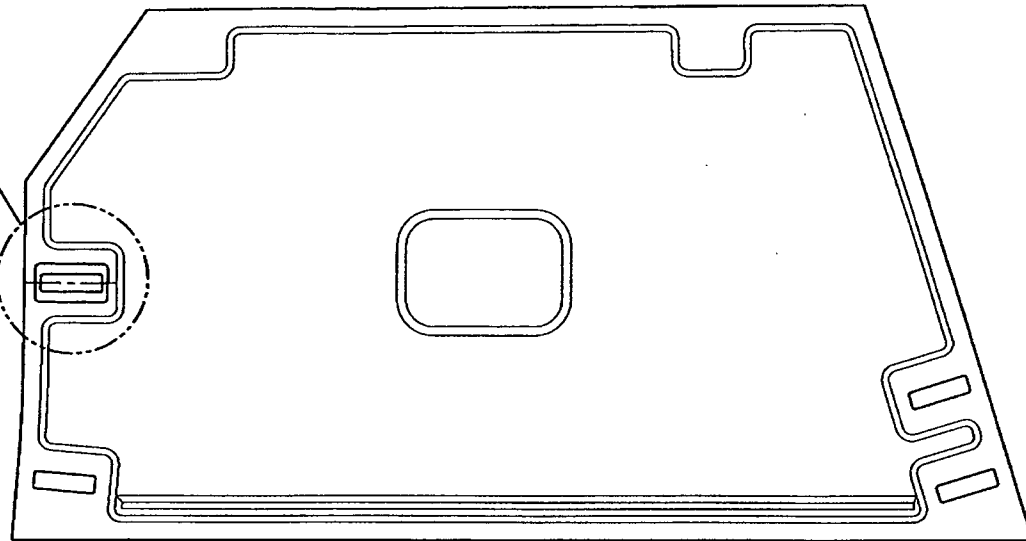
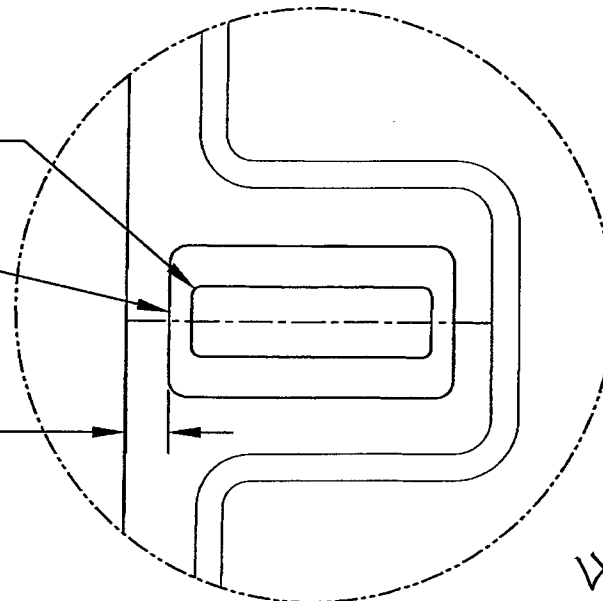


FIGURE 3: CUTTING LATCH HOLE

CUT HOLE THROUGH
SKIN USING D2621 AS
TEMPLATE

D2621 LATCH PLATE

0.60"
(15.2mm)



457404

DETAIL B

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.05.26
CERT. NO.: SH92-41
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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